

Work Order ID 154982***154982***

Page 1

Wednesday, January 04, 2017 2:13:28 PM

Item ID: D3793-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Wearplate Fwd

Start Date: 1/9/2017 Start Qty: 6.00

6

Cust Item ID:

Required Date: 1/16/2017 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals:

Process Plan:

DAS
21
9-89

Date: JAN 04 2017

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3793	Rev A

100

0.02

100

FLOW WATER JET

Waterjet

Memo

0.12

FLOW CNC Waterjet

1-Cut as per Dwg D3793 Dwg Rev: A Prog Rev: A 2-
Deburr if necessary

(6)

17/01/05

110

0.00

110

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.01

Quality Control

(6)

17/01/05

120

0.00

120

QC8- Inspect parts - second check

QC

Memo

0.02

Quality Control

(6)

17.01.00

DAS
9
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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154982

Page 2

Item ID: D3793-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Wearplate Fwd
Start Date: 1/9/2017 Start Qty: 6.00 ***6*** Cust Item ID:
Required Date: 1/16/2017 Req'd Qty: 6.00 ***6*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	NC BRAKE	0.02			DAS 30 9-89	6			JAN 13 2017
130 Brake NC	Memo	0.02							
Brake NC	1-Deburr if necessary 2-Form on Brake as per Dwg D3793 using Jigs 3-Form Joggle on brake using Jig as per Dwg D3793								
140	QC5- Inspect part completeness to step on W/O	0.00				6			JAN 13 2017
140 QC	Memo	0.02							
Quality Control									
150	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3	0.00							
150 Powdercoat	Memo	0.01							
Powder Coating	START TIME: 11:40 OVEN TEMPERATURE: 320° FINISH TIME: 12:10					6	0	17-01-18	320° 34 9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:12.5%;">Skid-tube ☐</td> <td style="width:12.5%;">Cross tube ☐</td> <td style="width:12.5%;">Water Jet ☐</td> <td style="width:12.5%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																	
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Work Order ID 154982

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154982

Page 3

Item ID: D3793-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Wearplate Fwd

Start Date: 1/9/2017 Start Qty: 6.00

6

Cust Item ID:

Required Date: 1/16/2017 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160

QC3- Inspect Part Finish

0.00

160

QC

Memo

0.01

Quality Control

DAS
38
9-88

FEB 01 2017

170

Identify as per dwg & Stock Location: FP-062 0.00***170***

Packaging

Memo

0.01

Packaging

LOCATION ; FP002

x6 d 17/02/02

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.10

Quality Control

17/02/02

 FEB 02 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
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Picklist Print

Wednesday, January 04, 2017 2:13:32 PM

Page 1

Work Order ID: 154982

154982

Parent Item: D3793-1

D3793-1

Parent Item Name: Wearplate Fwd

Start Date: 1/9/2017

Required Date: 1/16/2017

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A 08-05-13 new issue DD verified by:EC
IPP Rev:B 08-05-23 revA as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S20GA		Purchased		No		100	sf	96.0410	0.5902	3.727579			

M304S20GA

304/316 .040 Sheet

on 17/01/05

Location

Loc Qty

Loc Code

MAT020

95.22

m134495

0.2

m134982

0.1

m135327

7.72

m135689

23.2

m136327

64

MAT20

0.821

m133901

0.821

35

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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DART AEROSPACE LTD		Work Order:	154982
Description: Wearshoe		Part Number:	D3793-1
Inspection Dwg: D3793 Rev: A		Page 1 of 1	

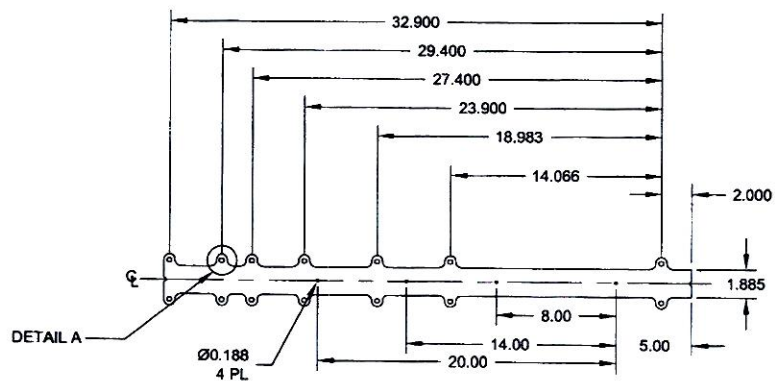
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

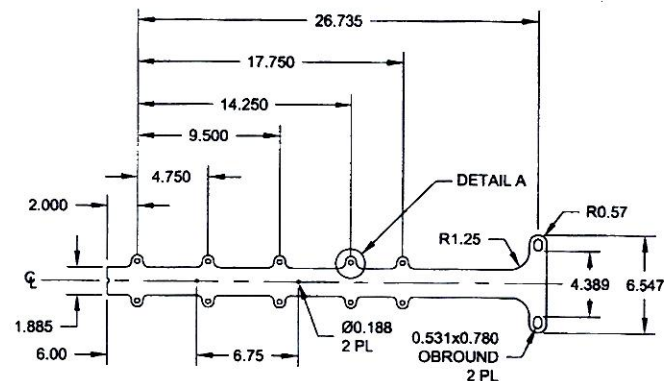
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.188	+0.005/-0.001	Ø.188	1		V: 2-01	
0.300 x 0.300	+/-0.010	.299 x .300	1		Tap	
1.885	+/-0.010	1.894	1			
2.000	+/-0.010	2.004	1			
5.00	+/-0.030	5.00	1			
8.00	+/-0.030	8.00	1			
14.00	+/-0.030	14.00	1			
20.00	+/-0.030	20.00	1			
14.066	+/-0.010	14.066	1			
18.983	+/-0.010	18.983	1			
23.900	+/-0.010	23.900	1			
27.400	+/-0.010	27.400	1			
29.400	+/-0.010	29.400	1			
32.900	+/-0.010	32.900	1			
0.040	+/-0.010	.035	1			

Measured by:	de	Audited by:	DAS 9	Prototype Approval:	N/A
Date:	16/01/05	Date:	17-01-05	Date:	N/A

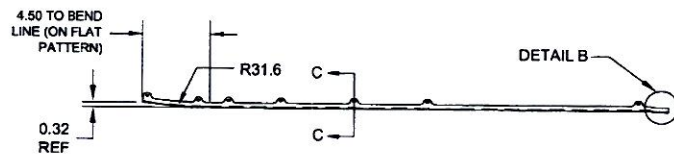
Rev	Date	Change	Revised by	Approved
A	08.05.30	New Issue	KJ/DD	



D3793-1F FLAT PATTERN



D3793-3F FLAT PATTERN



D3793-1 BEND DETAIL
(MAKE FROM D3793-1F)



D3793-3 BEND DETAIL
(MAKE FROM D3793-3F)

NOTES:

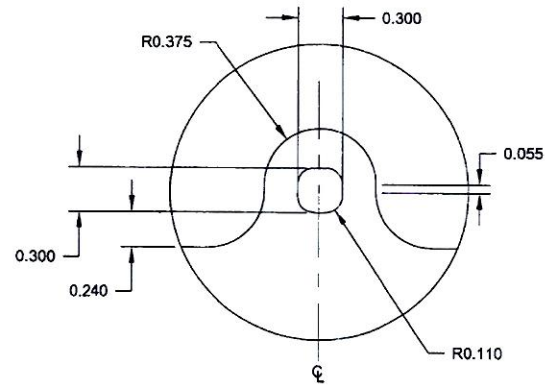
- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK)
(REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "DXXXX-X" ON INSIDE SURFACE USING FINE POINT PERMANENT INK MARKER OR LABEL AFTER FINISH
- 7) WEIGHT: D3793-1 - 0.72 LBS, D3793-3 - 0.66 LBS

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WORK ORDER
NO. 154982 MLJ
17-01-04

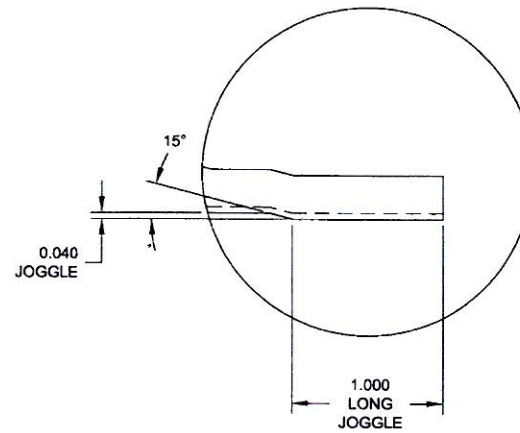
RELEASED
08-05-23/18

REV.	DESCRIPTION	PH	DATE
A	NEW ISSUE	PH	08.05.14
DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	PH	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3793	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		WEARSHOE	NTS
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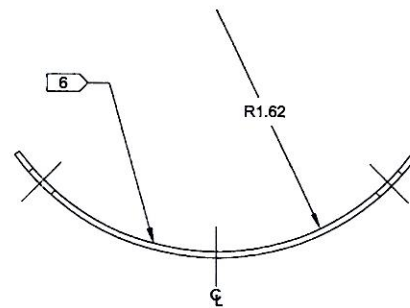
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DETAIL A
SCALE 10X



DETAIL B
SCALE 10X



SECTION C-C
SCALE 10X

RELEASED
08-05-23/1/1/1

DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	PH	PORT HADLOCK, WA	
CHECKED	IS	DRAWING NO.	REV. A
MFG. APPR.	IS	D3793	SHEET 2 OF 2
APPROVED	IS	TITLE	SCALE
DE APPR.	IS	WEARSHOE	NTS
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8 7 6 5 4 3 2 1